

Work Order ID 130518

Friday, March 13, 2015 12:56:38 PM

130518

Page 1

Item ID: D4543-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Retainer, LH Outer (Lower)
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MJS Date: 15-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4543	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1- Cut as per dwg								
6061-032	Prog rev: <u>B</u>								
	Dwg rev: <u>B</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(6) _____ 15/03/21
(6) _____ 15/03/21

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Page 2

Item ID: D4543-1 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							38 9-89
120									
QC	Memo	0.00							
Quality Control									

MAR 23 2015

130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- FORM ON BEAD ROLLER (DT9787), SET BACK GAGE TO .550", FROM BACK GAGE TO CENTER EDGE OF BOTTOM ROLLER								
	MAKE ONE AND ENSURE IT'S MADE AS PER DWG BEFORE MAKING QTY REQUIRED ON W/O								

MAR 24 2015

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAR 24 2015

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Item ID: D4543-1 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				6	PF		MAR 24 2015
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
160									
QC	Memo	0.00				6			
Quality Control									MAR 26 2015
170	Identify as per dwg & Stock Location: ST 630	0.00							
170									
Packaging	Memo	0.00							DAS 28 9-89
Packaging						Cox			MAR 27 2015

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Page 4

Item ID: D4543-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Retainer, LH Outer (Lower)

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

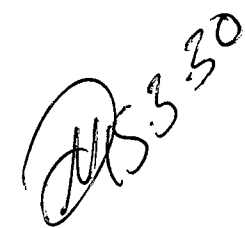
180

QC

Memo

0.00

Quality Control



Picklist Print

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Page 1

Work Order ID: 130518

130518

Parent Item: D4543-1

D4543-1

Parent Item Name: Retainer, LH Outer (Lower)

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD
REV:B 12.02.24 as per dwg reva DD verf:EC
13.04.23 as per dwg revB DD verf:JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	249.5213	0.611	4			

M6061T6S 032

6061-T6 Sheet 0.032"

DL 15/03/21

Location

Loc Qty

Loc Code

MAT021

249.5213

m130387

61.6667

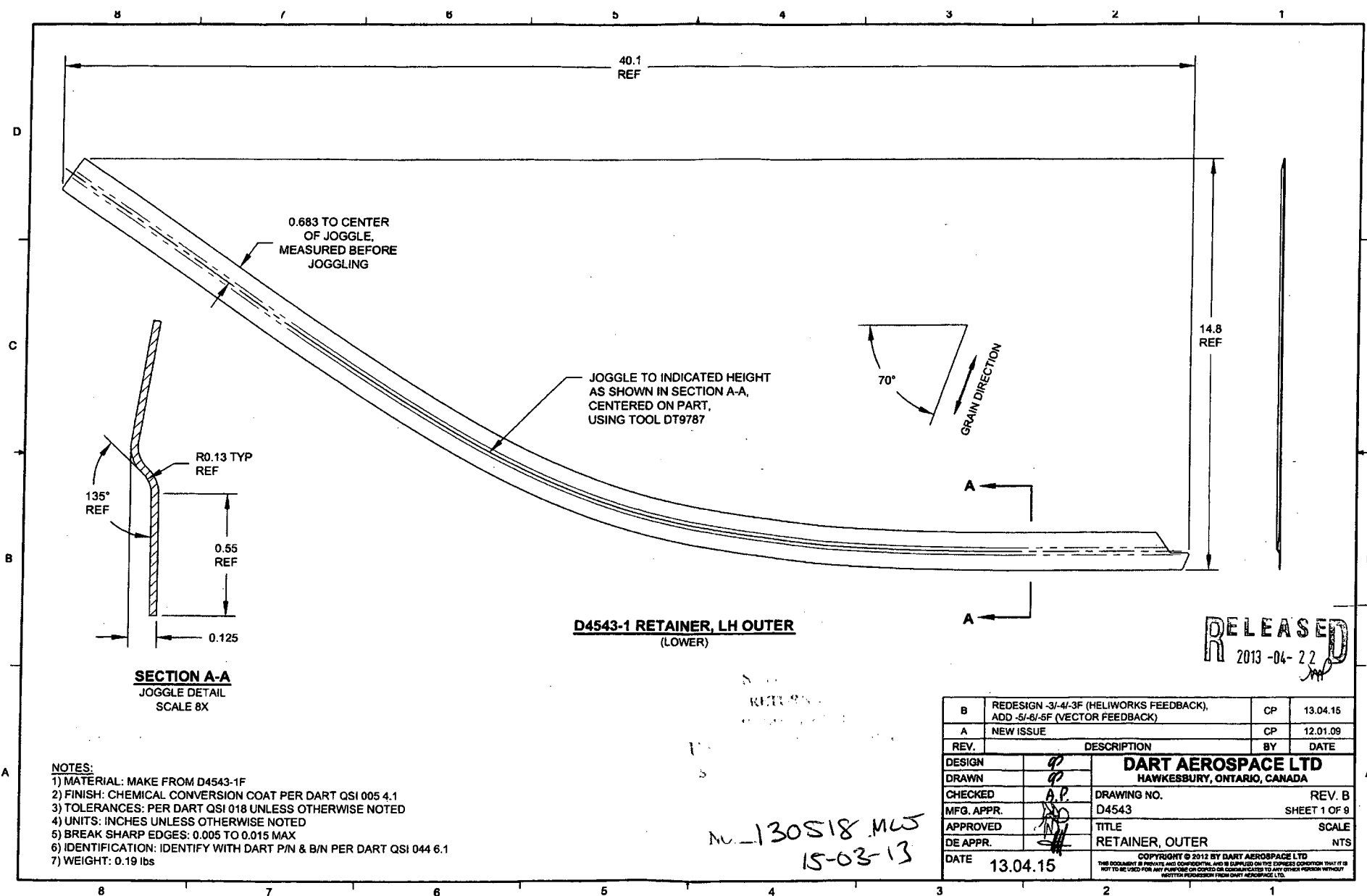
m130585

58.4546

m131332

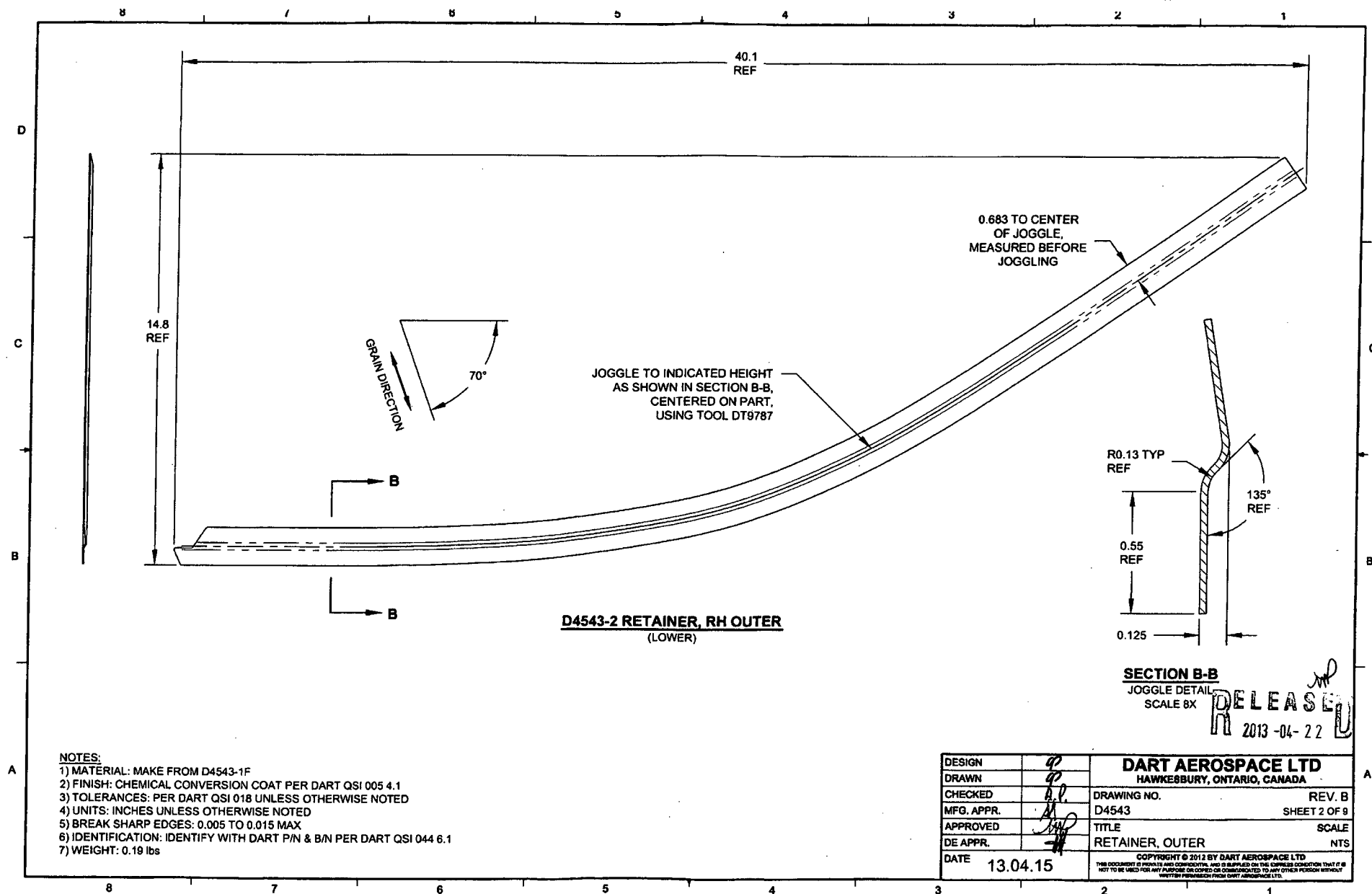
129.4

4.2

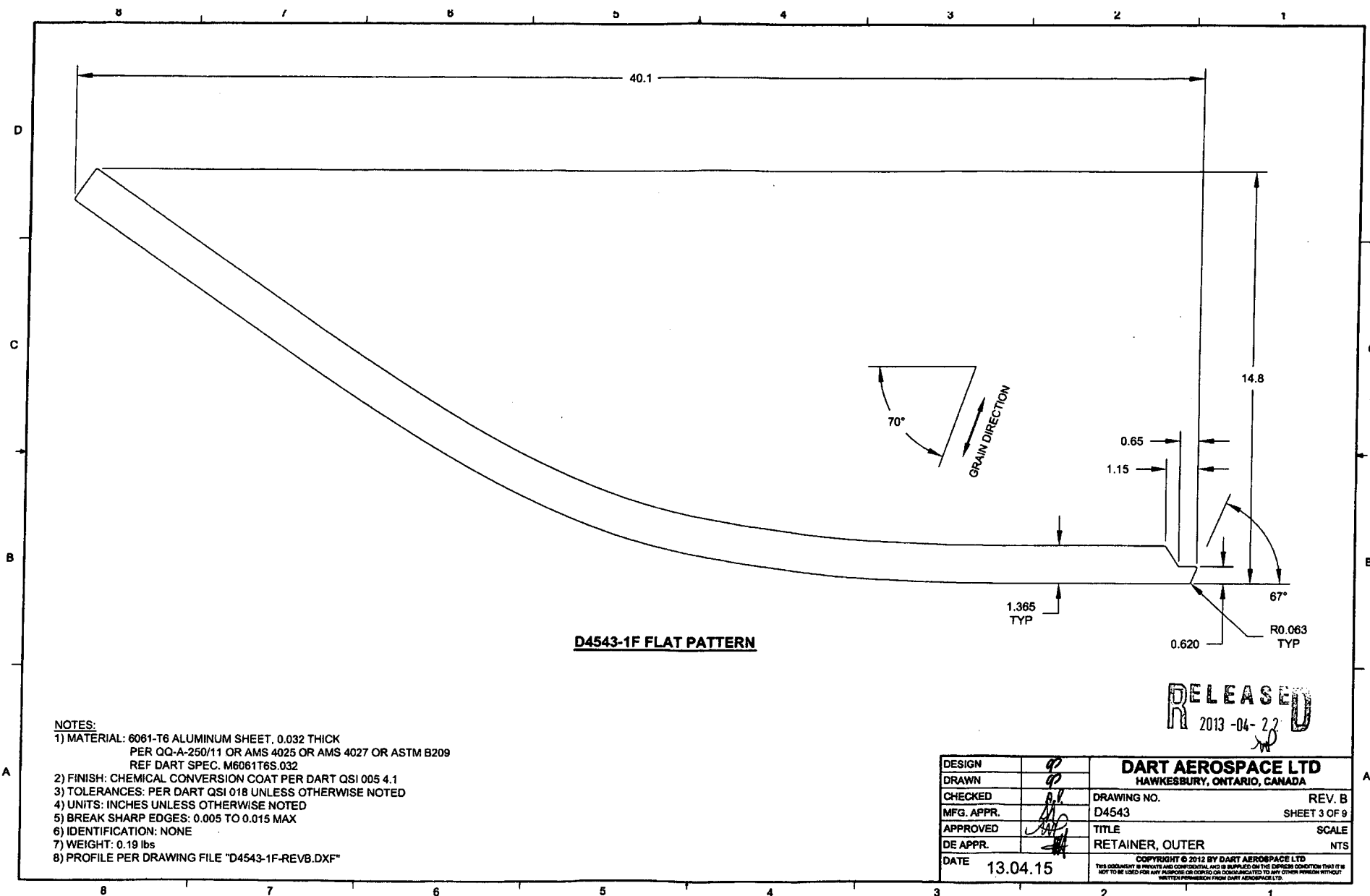


RELEASED
2013-04-22

B	REDESIGN -3/-4/-3F (HELIWORKS FEEDBACK), ADD -5/-6/-5F (VECTOR FEEDBACK)	CP	13.04.15
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	ND	D4543	SHEET 1 OF 9
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	RETAINER, OUTER	NTS
DATE	13.04.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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2013-04-22

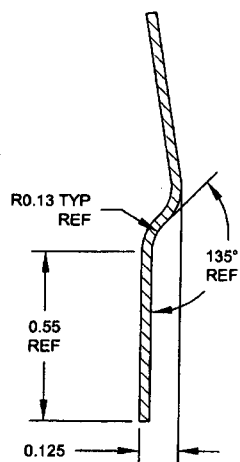


NOTES:

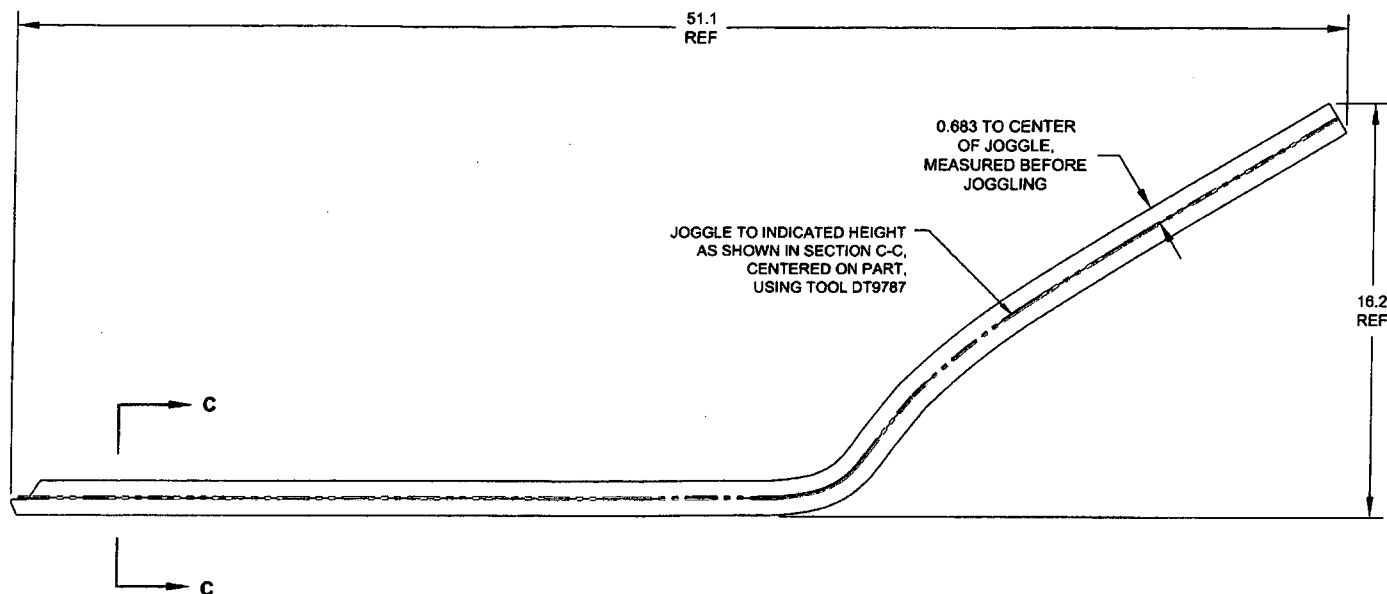
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REV8.DXF"

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2013-04-22

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	AL	DRAWING NO.	REV. B
MFG. APPR.	MD	D4543	SHEET 3 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	RETAINER, OUTER	NTS
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SECTION C-C
JOGGLE DETAIL
SCALE 12X



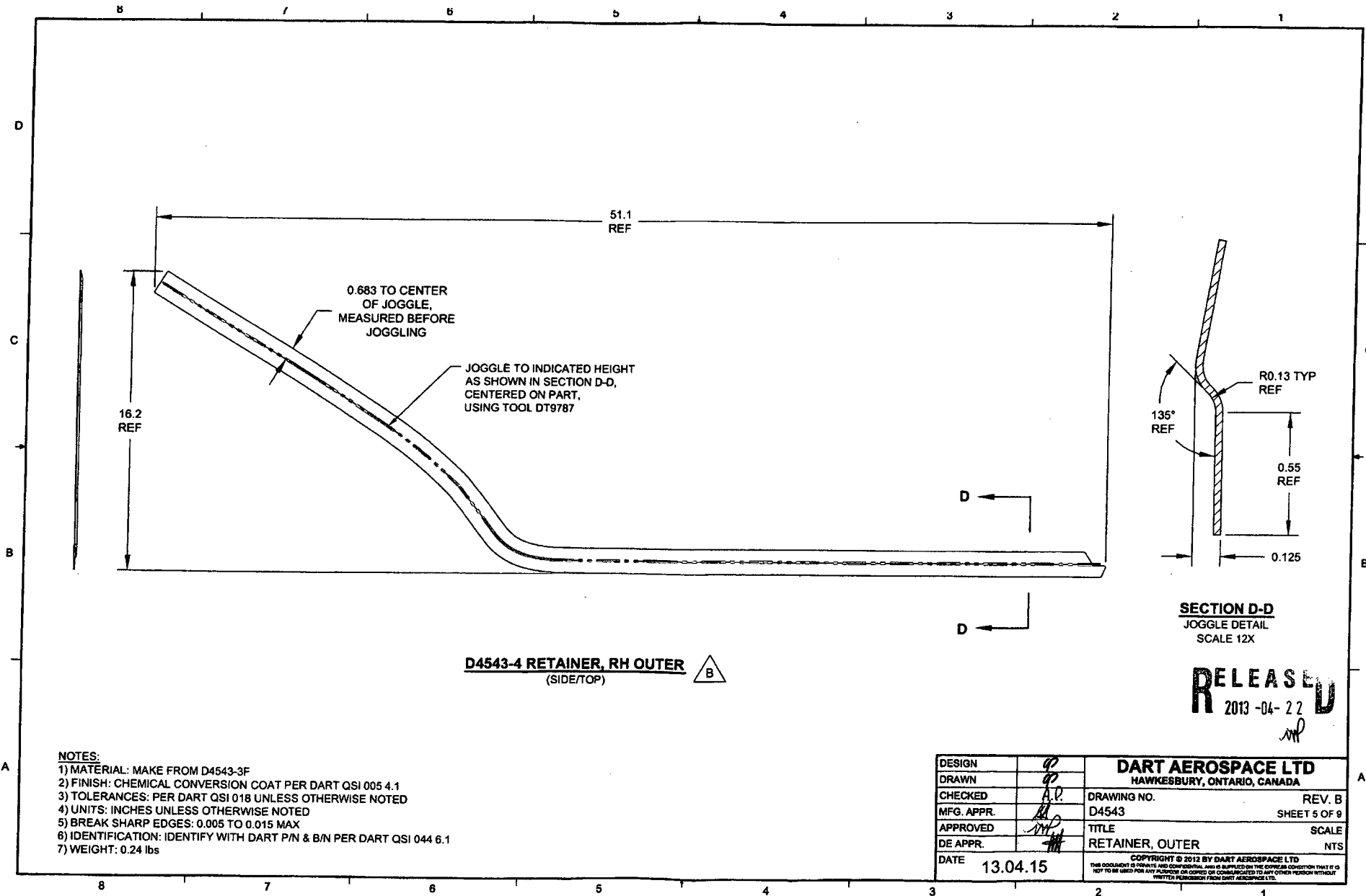
D4543-3 RETAINER, LH OUTER
(SIDE/TOP) B

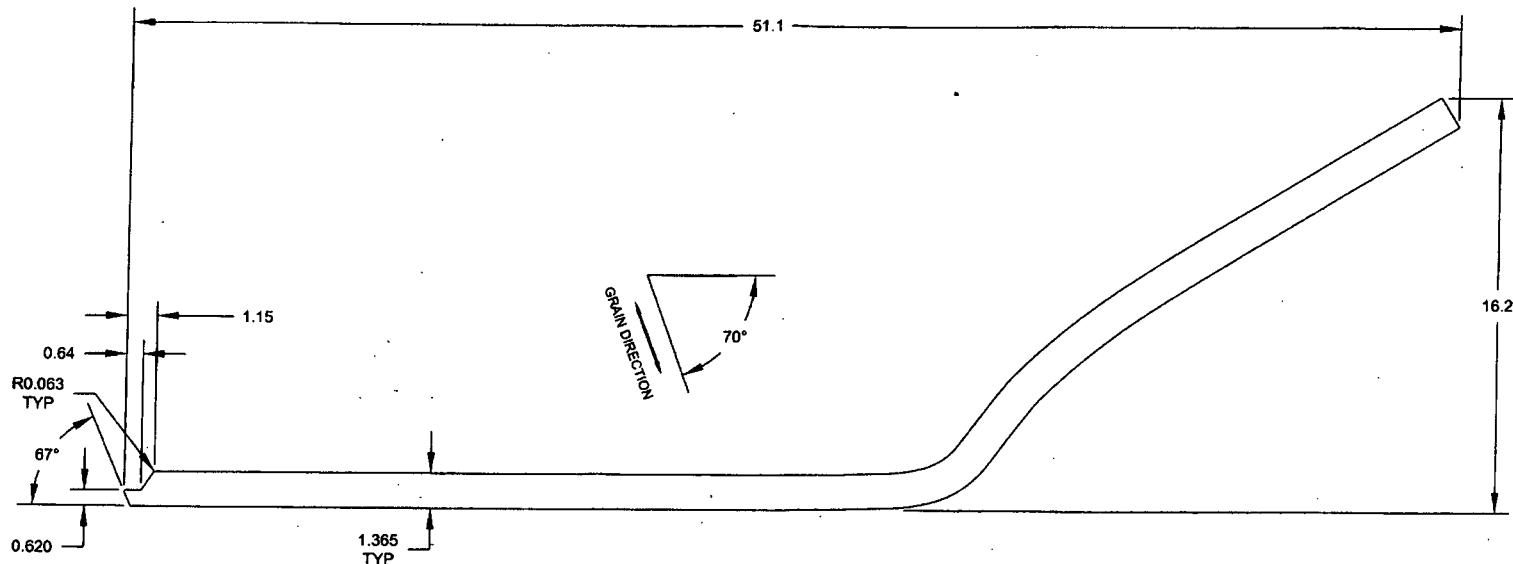
RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AL	DRAWING NO.	REV. B
MFG. APPR.	AS	D4543	SHEET 4 OF 9
APPROVED	MS	TITLE	SCALE
DE APPR.	TH	RETAINER, OUTER	NTS
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D4543-3F FLAT PATTERN

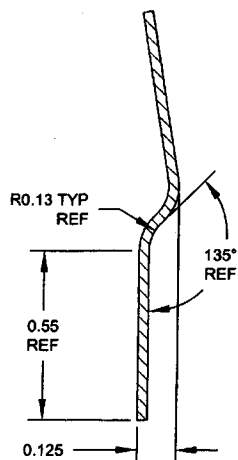


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2013-04-22
JND

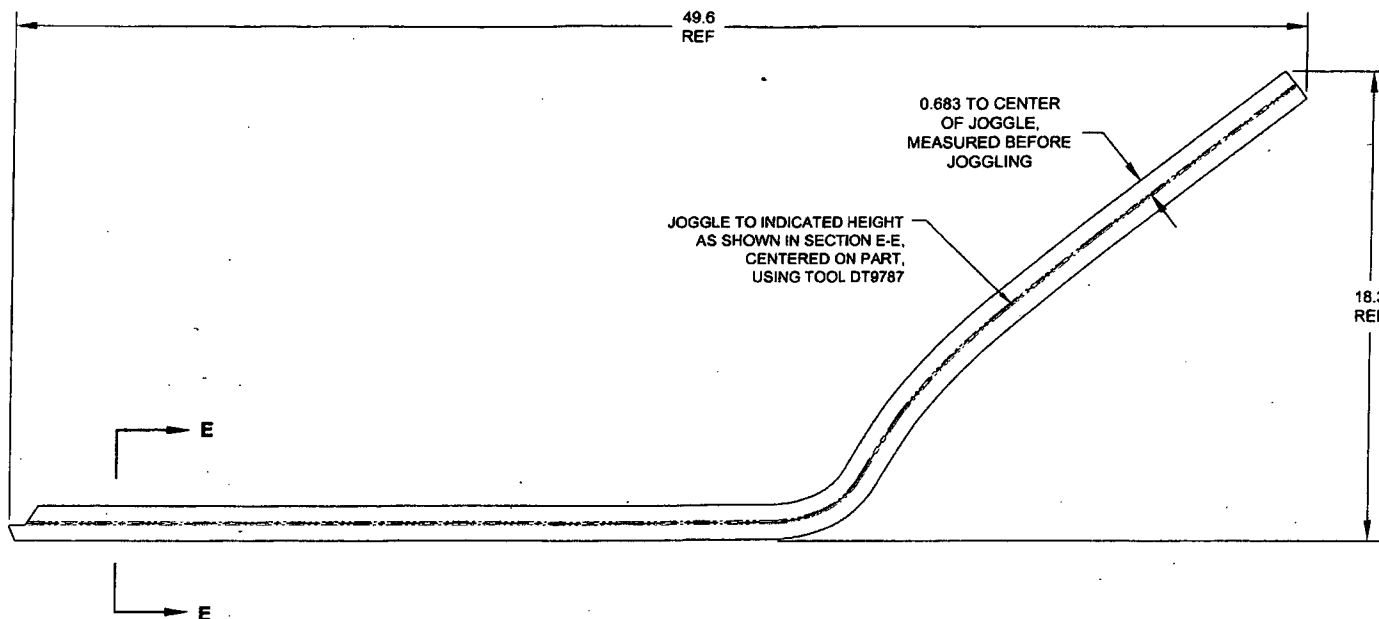
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

DESIGN	9	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	9		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	MA	D4543	SHEET 6 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	ST	RETAINER, OUTER	NTS
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SECTION E-E
JOGGLE DETAIL
SCALE 12X



D4543-5 RETAINER, LH OUTER
(SIDE/TOP)

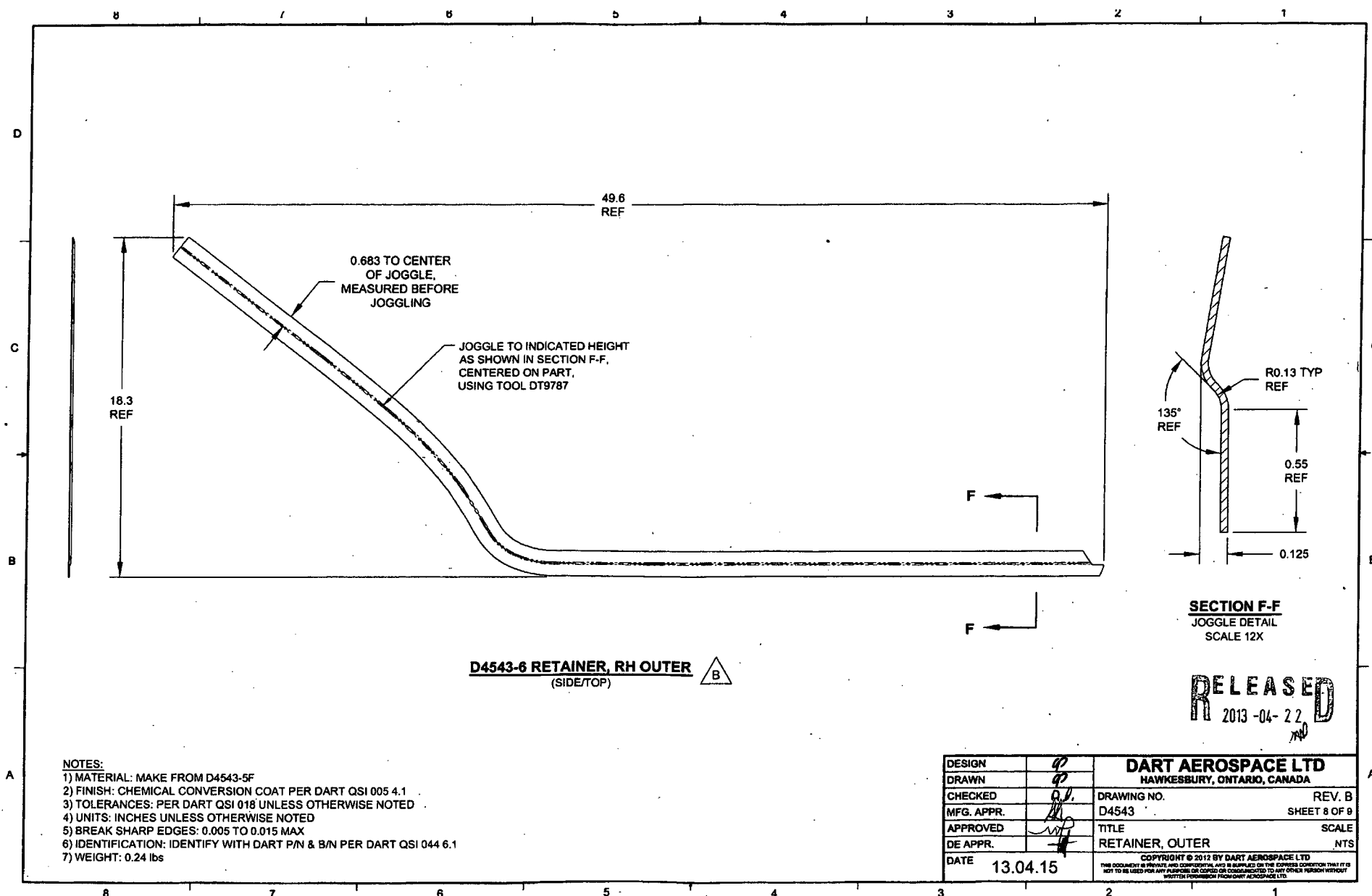


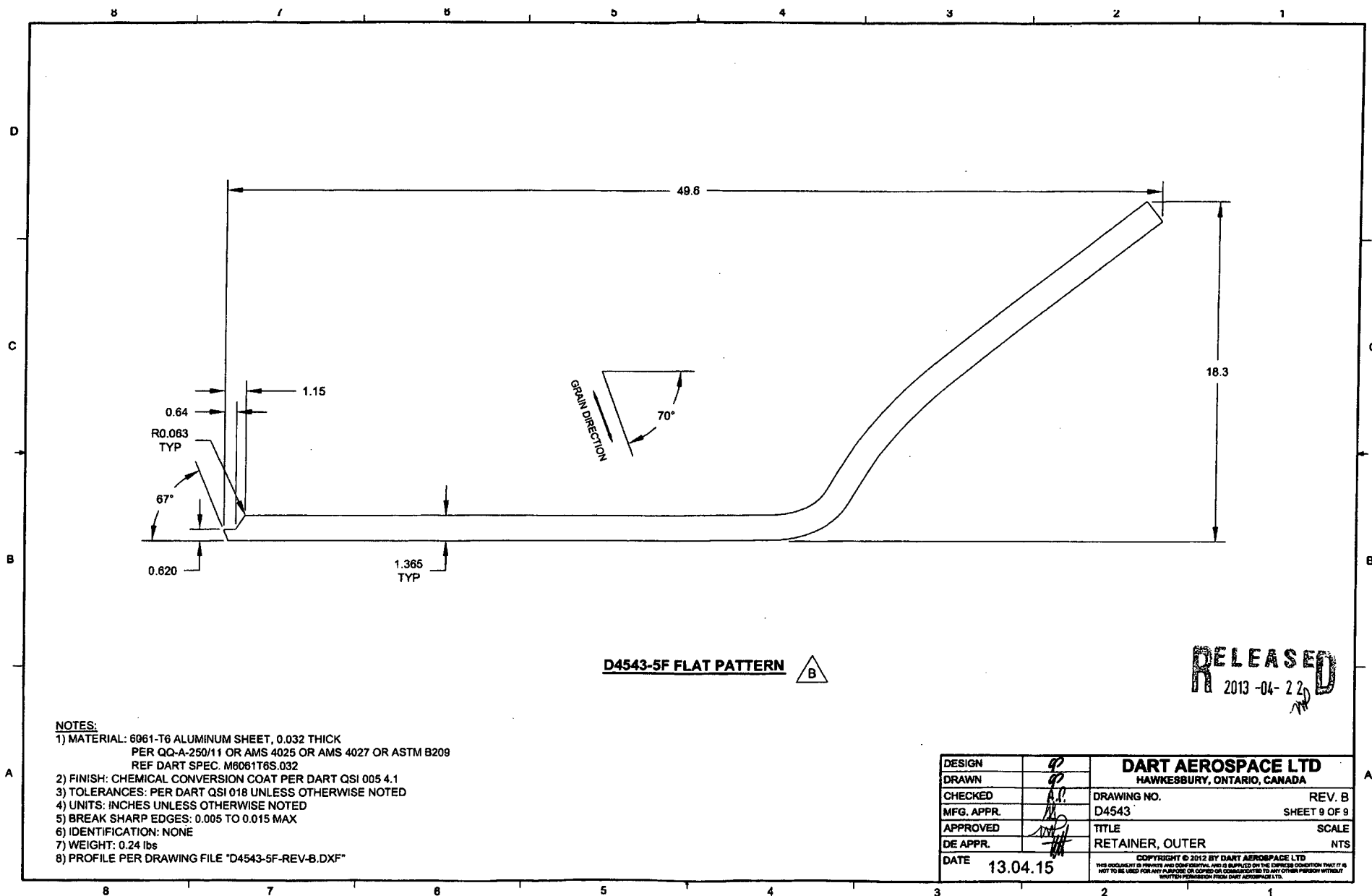
NOTES:

- 1) MATERIAL: MAKE FROM D4543-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	90	D4543	SHEET 7 OF 9
APPROVED	90	TITLE	SCALE
DE APPR.	90	RETAINER, OUTER	NTS
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